

Work Order ID 110470

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110470

Page 1

Item ID: D135-751-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube (Fits LH or RH)
 Start Date: 12/20/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/03/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3507	Rev <u>C</u>								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo <u>M. KD-</u>	0.00							
Document Control	Photocopy bluefile & type labels per PPP D135-751-011		CHG002						

DAS
6
9-89

17-1-31

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Item ID: D135-751-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire-hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES*****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297"

9-Open ground wire hole .297" section E-E

10-Open Aft & Fwd Cap holes using .208" drill.

11-Bore out aft end of tube as per Dwg D3507 & Detail "B".

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

14/01/12 mm

OC 19/01/14

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Stop *NR2*

Quality Control

14-1-14

De 14/01/19

DAW
14-1-14

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Item ID: D135-751-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

170

Skidtubes

0.00

Skidtubes

Memo1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507.
and section G-G to .750" (2 places)

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 127097
Exp Date: 14/08/16
start time: 3:45
end time: 15/14/01/15

5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G

A/R AL ROD Batch: M122324

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

DE 14/01/14

BE 14/01/15

BE 14/01/15

7 BE 14/01/15

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Item ID: D135-751-011

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Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180 QC10- Inspect visual per QSI004- ground welds 0.00

180

QC Memo 0.00

Quality Control

① 14-01-15 DAS 9 9-89

190 Skidtubes 0.00

190

Skidtubes Memo 0.00

Skidtubes 1-Rivet D3506-1/-3 as per Dwg D3507.

Dec 14/01/15

200 QC5- Inspect part completeness to step on W/O 0.00

2000

QC Memo 0.00

Quality Control

① 14-01-17 DAS 9 9-89

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 Required Date: 1/03/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210	Pressure Wash per QSI005 4.3	0.00				1	76	14-1-22	
-----	------------------------------	------	--	--	--	---	----	---------	--

210

HandFinish	Memo	0.00							
------------	------	------	--	--	--	--	--	--	--

Hand Finishing Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220	White Gloss (Ref 4.3.5.1) per QSI005 4.3. Alarm	0.00				1	0	0	A8
-----	---	------	--	--	--	---	---	---	----

220

Powdercoat	DAS	10							
------------	-----	----	--	--	--	--	--	--	--

Powder Coating 9-89

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

DAS
10
9-89

① prime and paint as per day
 primer batch: 126543
 paint batch: 128009

230	QC3-Inspect Part Finish	0.00				1			
-----	-------------------------	------	--	--	--	---	--	--	--

230

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

DAS
10
9-89

310
14-1-22

7



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1 10470

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube (Fits LH or RH)

Stop *NS2*

Start Date: 12/20/13 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 1/03/14 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

260

0.00

260

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: 11127097
Exp Date: 14/08

3-Install Wearplates as per Dwg D3507 ,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Screws where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: 111 122 093
Exp Date: 14/09

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M 17165

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 14126051

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Item ID: D135-751-011 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00		DAS 31 9-80		14-2-5			DAS 6 9-80
300	Packaging	0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: <u>6H</u>								
	PPP Rev: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

MLJ 14-02-05

MLJ 14-02-05

Picklist Print

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Work Order ID: 110470

110470

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E
 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F 10.06.09
 remove seq110 DD verf:EC IPP Rev G 10.09.17 added
 D3507-1-bent EC verified by:DD IPP REV:H 13.12.11 ECN13-619/
 CHG002 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130

Purchased

No

Each

2,112.000

38

AI S7-1032-130

Rivnut

Location

Loc Qty

Loc Code

FG

100

121444

100

ST279

2012

119530

73

122763

38

124226

50

m126109

1851

x38

D3507-1-BENT

Manufactured

No

120

Each

6.0000

1

1

D3507-1-BFNT

Skidtube Assembly EC135

Location

Loc Qty

Loc Code

LG002

6

102577

2

104673

2

104674

2

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Work Order ID: 110470

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3504-1

Manufactured No

170

Each

22.0000

2

2

D3504-1

Crossbolt Spacer

BE14/01/15

Location

Loc Qty

Loc Code

LG001

22

98007

22

2

D3504-3

Manufactured No

170

Each

66.0000

1

1

D3504-3

Crossbolt Spacer

BE14/01/15

Location

Loc Qty

Loc Code

LG001

66

105604

53

31232

11

82726

2

1

D3504-5

Manufactured No

170

Each

25.0000

2

2

D3504-5

Crossbolt Spacer

BE14/01/15

Location

Loc Qty

Loc Code

LG001

25

106024

25

2

D3505-1

Manufactured No

170

Each

3.0000

1

1

D3505-1

Web

DE 14/01/14

Location

Loc Qty

Loc Code

LG002

3

106459

3

11

Picklist Print

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Work Order ID: 110470

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3506-1 Manufactured No

190 Each

35.0000 4 4

D3506-1

Doubler

**

DC 14/01/15

Location

Loc Qty

Loc Code

ST052

35

10626

30

88517

5

3
1

D3506-3 Manufactured No

190 Each

25.0000 2 2

D3506-3

Doubler

**

DC 14/01/15

Location

Loc Qty

Loc Code

ST052

25

51790

25

2

MS20601-AD4W3 Purchased No

190 Each

1,380.000 12 12

MS20601-AD4W3

Rivet

**

DC 14/01/15

Location

Loc Qty

Loc Code

ST311

500

114538

500

ST506

880

124331

600

124365

280

12

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Work Order ID: 110470

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

260

Each

469.0000

1

1

AI S4-1032-225

Rivnut

ll 12/01/29

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST280

10

M127028

10

st555

429

M127092

429

x1

AN3C4A

Purchased

No

260

Each

2,777.0000

31

31

AN3C4A

Bolt

ll 12/01/29

Location

Loc Qty

Loc Code

FG

20

122814

20

ST513

2757

125388

1863

M127410

894

x31

AN3C5A

Purchased

No

260

Each

164.0000

2

2

AN3C5A

Bolt

ll 12/01/29

Location

Loc Qty

Loc Code

FG

5

M1128057

x2

122800

5

ST350

159

m127290

159

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Work Order ID: 110470

110470

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10

Purchased

No

260

Each

76.0000

2

2

AN526C1032R10

Screw

Location

Loc Qty

Loc Code

FP001

34

108062

34

ST346

42

m126857

42

D2965

Manufactured

No

260

Each

42.0000

1

1

D2965

Cap

Location

Loc Qty

Loc Code

FP001

42

80089

11

99551

31

D2965-3

Manufactured

No

260

Each

15.0000

1

1

D2965-3

Cap

Location

Loc Qty

Loc Code

FP001

15

98923

15

D3492-1

Manufactured

No

260

Each

195.0000

4

4

D3492-1

Plug

Location

Loc Qty

Loc Code

FP001

195

104844

195

Picklist Print

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Work Order ID: 110470

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

260

Each

277.0000

4

4

D3492-3

Plug

**

HL 12/01/29

Location

Loc Qty

Loc Code

FP001

277

104853

72

107331

105

109800

100

X4

D3492-7

Manufactured No

260

Each

117.0000

2

2

D3492-7

Plug

**

HL 12/01/29

Location

Loc Qty

Loc Code

FP001

117

106110

101

86759

16

260

Each

6.0000

2

2

D3512-041

Manufactured No

D3512-041

Wearplate Assembly

**

DAS
28
9-89

14-01-30

Location

Loc Qty

Loc Code

prelim

2

104832

2

ST500

4

109985

4

260

Each

2.0000

1

1

D4918-047

Manufactured No

D4918-047

Wearplate Assembly

**

HL 12/01/29

Location

Loc Qty

Loc Code

prelim

2

109004

2

X1

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Work Order ID: 110470

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D4918-1 Manufactured No

260 Each 4.0000 1 1

D4918-1

Wearplate

**

HL 12/01/29

Location

Loc Qty

Loc Code

prelim

4

109954

4

D4918-3 Manufactured No

260 Each 4.0000 1 1

D4918-3

Wearplate

**

HL 12/01/29

Location

Loc Qty

Loc Code

prelim

4

109955

4

D4918-5 Manufactured No

260 Each 4.0000 1 1

D4918-5

Wearplate

**

HL 12/01/29

Location

Loc Qty

Loc Code

prelim

4

109956

4

NAS1149C0332R Purchased No

260 Each 9,547.000 33 33

NAS1149C0332R

WASHER

**

HL 12/01/29

Location

Loc Qty

Loc Code

GA

1277

125654

1277

st510

8270

m126319

2770

m127306

2500

m127410

3000

x 33

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

366.0000

2

2

NAS1611-007

O-RING

HL 14/01/29

Location

Loc Qty

Loc Code

FP001

366

103697

366

XZ

NAS1611-010

Purchased

No

260

Each

45.0000

4

4

NAS1611-010

O-RING

HL 14/01/29

Location

Loc Qty

Loc Code

FP001

45

m126988

45

M127813

X4

NAS1611-013

Purchased

No

260

Each

16.0000

4

4

NAS1611-013

O-RING

HL 14/01/29

Location

Loc Qty

Loc Code

FP001

16

125445

16

M127813

X4

AN3C4A

Purchased

No

280

Each

2,777.000

8

8

AN3C4A

Bolt

DAS
28
9-89

14-01-30

Location

Loc Qty

Loc Code

FG

20

122814

20

ST513

2757

125388

1863

M127410

894

8X

DAS
31
9-89

S
DAS
6-9
9-89

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110470

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube (Fits LH or RH)

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

280

Each

9,547.000

8

8

NAS1149C0332R

WASHER

**

DAS

28

9-89

14-01-30

Location

Loc Qty

Loc Code

GA

1277

125654

1277

st510

8270

m126319

2770

m127306

2500

m127410

3000

127831

DAS
6
9-89

DAS
81
9-89

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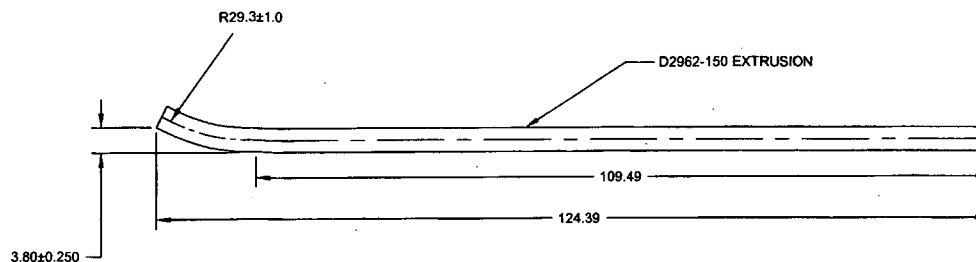
Shop Packet Print

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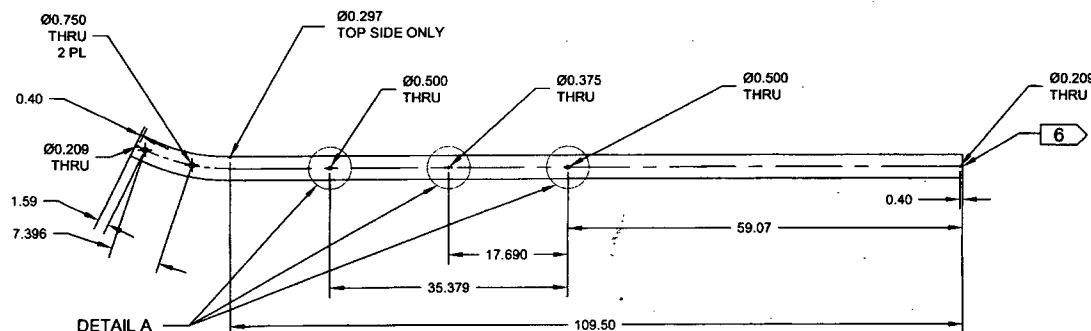
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

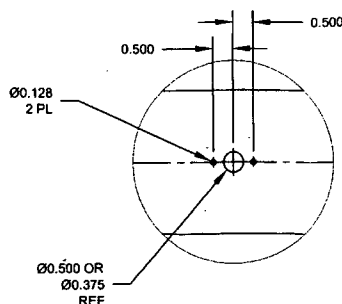
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



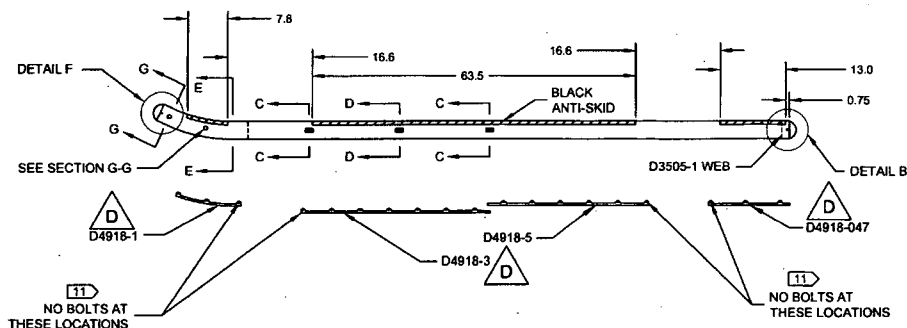
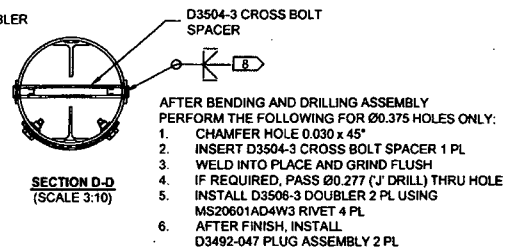
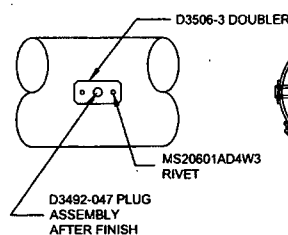
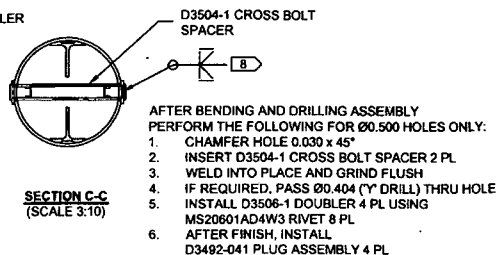
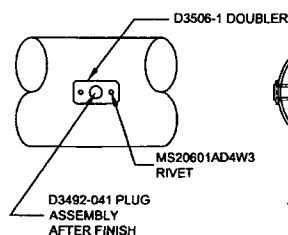
D3507-1 DRILLING DETAIL



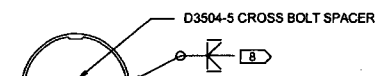
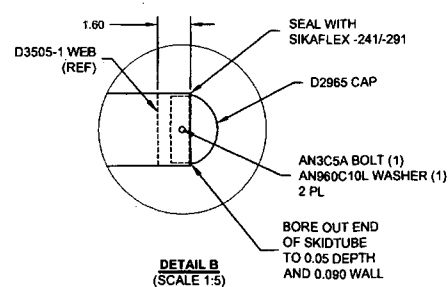
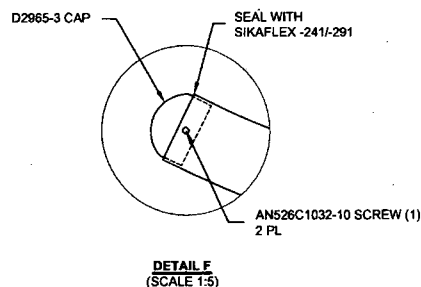
DETAIL A
TYP, 6 PL
SCALE 3:10

D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

110470 MJS
13-12-20

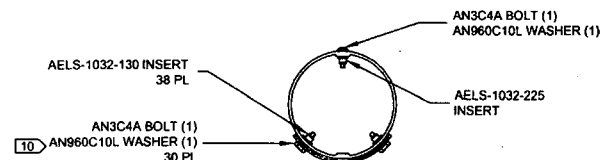


D3507-041 ASSEMBLY DETAIL



AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
3. WELD INTO PLACE AND GRIND FLUSH
4. IF REQUIRED, PASS Ø0.594 (1/8" DRILL) THRU HOLE
5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



SECTION E-E (SCALE 3:10)

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
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RELEASED
2013-12-13

NO. 328

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: B105713
Part #: A135-751-011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>] fail[]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>] fail[]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>] fail[]
Cracks:	pass[<input checked="" type="checkbox"/>] fail[]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>] fail[]
Undercut:	pass[<input checked="" type="checkbox"/>] fail[]
Pin holes:	pass[<input checked="" type="checkbox"/>] fail[]
Porosity (surface):	pass[<input checked="" type="checkbox"/>] fail[]
Coloration:	pass[<input checked="" type="checkbox"/>] fail[]
Burn through:	pass[<input checked="" type="checkbox"/>] fail[]

Qualifier David Hume Date of Test Coupon 13-09-18

Welder Barclay Elliott Date of Test Coupon 13-09-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld